



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

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D4855-1

Job Sheet 200414



Part No: D4855-1

Job Qty: 12 pcs

Part Name: Antenna Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/11/19

Job Tracking No:

Due Date: 10/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 1 IPP REV: A NEW ISSUE JFS 13/06/26 VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	10/2/19	10/2/19	0.00	0.34	Bandsaw - 1		DIP 19-10-11
110	HAAS 4 Axis - B4B	12 pcs	10/2/19	10/2/19	0.29	10.53	HAAS - 1 - B4B		DIP 19-10-11
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	12 pcs	10/2/19	10/2/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		J.C. 19-10-15
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



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CANADA
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Container No: S222406



Part: D4855-1

Job No: 200414

Serial No/Batch: S222406

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/15/19

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140	Handfinish - 1-1 Chemical-B4B	12 pcs	10/2/19	0.00	0.48	QC 8 - 76	
						Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	 OCT 15 2019
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	QC 7	12 pcs	10/2/19	0.00	0.00	QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	 B1 A-10-16.
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	

						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 76	
160	Powdercoat - 1 White Gl(A)- B4B	12 pcs	10/2/19	0.00	0.23	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
170	QC 3	12 pcs	10/2/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
180	Packaging 3-1 - Stock - B4B	12 pcs	10/2/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 -	

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					B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	Pc STS26
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	12 pcs	10/2/19	0.00	0.00	QC 21 - SA - 21	21 OCT 21 2019
					QC 21 - SA - 70	9-89
					QC 21 - SA - 53	

Part Op 100 - (Bandsaw) CUT BLANK AT 3.000"
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB200
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B4.500X4.500	6061-T6 Aluminumbar 4.500" X 4.500" (CUT IN SECTION 6ft)	3 ft (.25 ea)	100-Bandsaw - 1	S168973 S121736

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B4.500X4.500	3	11	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Antenna Bracket	0.875Inches ± 0.010	0.885 0.865	0.875	
2	Antenna Bracket	0.201Inches $+ 0.005$ $- 0.001$	0.206 0.200	0.202	Diameter
3	Antenna Bracket	0.970Inches ± 0.030	1.000 0.940	0.970	
4	Antenna Bracket	0.970Inches ± 0.030	1.000 0.940	0.970	
5	Antenna Bracket	1.880Inches ± 0.030	1.910 1.850	1.880	
6	Antenna Bracket	3.750Inches ± 0.030	3.780 3.720	3.750	
7	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	0.250	Radius
8	Antenna Bracket	0.257Inches $+ 0.005$ $- 0.000$	0.262 0.257	0.258	Diameter
9	Antenna Bracket	2.130Inches ± 0.030	2.160 2.100	2.125	
10	Antenna Bracket	1.400Inches ± 0.030	1.430 1.370	1.400	
11	Antenna Bracket	1.260Inches ± 0.030	1.290 1.230	1.260	
12	Antenna Bracket	1.880Inches ± 0.030	1.910 1.850	1.877	
13	Antenna Bracket	0.280Inches $+ 0.006$ $- 0.001$	0.286 0.279	0.280	Diameter
14	Antenna Bracket	0.380Inches ± 0.030	0.410 0.350	0.380	Radius
15	Antenna Bracket	0.380Inches ± 0.030	0.410 0.350	0.380	Radius
16	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	0.250	Radius
17	Antenna Bracket	0.250Inches ± 0.010	0.260 0.240	0.252	
18	Antenna Bracket	2.500Inches ± 0.030	2.530 2.470	2.498	
19	Antenna Bracket	0.250Inches ± 0.010	0.260 0.240	0.246	
20	Antenna Bracket	4.250Inches ± 0.030	4.280 4.220	4.248	
21	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	0.250	Radius

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9-89DJP
19-10-10



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐

Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

MRB (QS1042)

Date: _____ Sequence #: _____

QTY Affected: _____

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: